



Installing drive flange

WARNING

Equipment which is faulty, installed incorrectly or not in accordance with specifications may become loose or drop off and cause serious injury.
Risk of knocks or crushing!
Liquids emerging under high-pressure can lead to serious injury!
Hydraulic installation/removal must be carried out only by qualified personnel. Only use specified and tested equipment.
The specified expansion and push-on pressure must not be exceeded.
During the installation/removal procedure, make sure that nobody is standing in the danger area. Do not attempt to bend or exert force on H.P. lines.
Always wear protective gloves and protective goggles/protective mask.

Coat O-ring with petroleum jelly and fit on crankshaft gear (pinion) - see also overview drawing C-095.05.01

Clean and degrease taper of crankshaft and drive flange.

Coat running surface of crankshaft bearing and drive flange with oil.

Coat tip of neck of oil seal with petroleum jelly.

WARNING

Heavy object.
Risk of injury!
Use suitable tools and lifting equipment.

Mount driver flange on crankshaft taper.

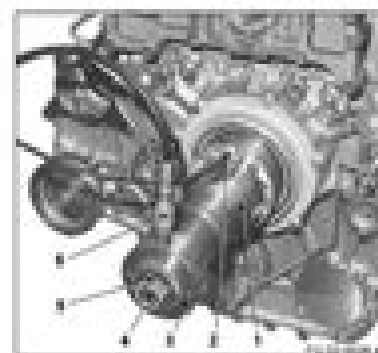
To calculate force-on distance, measure distance from end face of crankshaft to end face of drive flange using depth gauge. Write a note of this figure.

Calculate difference (push-on distance) between measured dimension and push-on dimension B - see C-095.05.01

Push-on dimension B = distance from face of crankshaft to face of drive flange after hydraulic installation.

Force-on distance is stamped on drive flange.

If calculated distance is less than push-on distance B, check dimensional accuracy of taper.



Screw drive spindle (4) into crankshaft.

Check reference dimension A - see C-095.05.01.

Mount pressure sleeve (7) and hydraulic press (8) over spindle.

Install nut (6) and hand-tighten.

Note: When fitting the nut up to the stop, the hydraulic press must be at its initial position (5 stroke).

Screw connector (2) into drive flange and connect H.P. line.

Connect H.P. line (3) of Lateral hand pump to hydraulic press.



Fill hydraulic hand pump with SAE 15 engine oil. Prime pump and lines until oil escaping is free of bubbles.

Tighten high-pressure line.

Before press-fitting, coat taper faces with expansion fluid: operate hydraulic hand pump (7) until expansion fluid escapes at drive flange end.

Operate Lateral hand pump (3) for hydraulic press and, to applying maximum pressure, seat press against driver flange.

Operate pump for expansion fluid until no further increase in expansion pressure (p1) is possible. Then increase force-on pressure (p2) by operating force-on pump.

Repeat this process until driver flange is correctly seated.

Repeat force-on pressure such as to seat shaft in approx. 5 steps.

During installation, do not allow the expansion pressure to exceed the maximum permissible expansion pressure Pmax.

From see specification on drive flange.

The installation procedure has concluded when the pressure built is at the stop on the crankshaft.

Note: Repeat pressure loss (P0)

Open valve screw in hydraulic oil pump to release expansion pressure.

Maintain maximum force-on pressure for 60 minutes, to ensure that the expansion fluid is expelled from the joint and static friction can build up between the fixed components.

Disconnect high-pressure line.

Allow specified retention time to elapse and remove nut, hydraulic press, pressure sleeve and drive spindle.

Note: Do not subject gears fitting in operating load for at least 8 hours.

Check push-on dimension B - see C-095.05.01, crankshaft and face to driver flange and face.

If push-on dimension is not achieved, hydraulically remove drive flange and determine the cause.

Remove oil from expansion bore in drive flange, screw in and tighten plug.

Mtu 16v 4000 Gx0 Gx1 Diesel Engine Full Service Repair Manual

RD Boyd



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